



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBEM625V3006101
Job Sheet 173656



Part No: RBEM625V3006101

Job Qty: 1 pcs

Part Name: Mast Nut Extractor



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/6/18

Job Tracking No:

Due Date: 5/10/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: RBEM625V3006101 REV.C SHEET 1,3 IPP Rev.A 17.08.24 New issue DP Verify DD IPP REV:B 17.11.15 AS
PER DWG REV.C DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		5/9/18	0.00	0.00	Start Up Small Fab-3		MLC
110	Small Fab	1 pcs		5/10/18	0.00	1.00	Small Fab-4		MLC
120	QC	1 pcs		5/10/18	0.00	0.00	QC5		MLC
130	Packaging	1 pcs		5/10/18	0.00	0.00	Packaging3-1		MLC
140	QC	1 pcs		5/10/18	0.00	0.00	QC21		MLC

GA

Part Op 110 - 1-Engrave placard RB41011 using marktronic engraver as per Dart QSI 044 2-Transfer drill Dart placard RB41011
Descriptions: into Pelican case APP-1400E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case as per
DWG 5-Hot Glue placard RBEM625V3006101-3 to RBEM625V3006101-7 foam as per DWG. 6-Hot Glue
RBEM625V3006101-5/-7 foam to Pelican Case as per DWG. 7-Pack case as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
90128A287 62	Socket Head Cap Screw M10 x 1.5mm x 30mm	3 Ea (3 ea)	90-Start up Operation	5M1384753
97524A032 40	Blind Rivet	4 Ea (4 ea)	90-Start up Operation	3031249
APP-1400-E	Case	1 Ea (1 ea)	90-Start up Operation	3060684
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	90-Start up Operation	3021040
RBEM625V3006101-1	Base	1 Ea (1 ea)	90-Start up Operation	3066640
RBEM625V3006101-3	Placard, Plastic	1 Ea (1 ea)	90-Start up Operation	3069754
RBEM625V3006101-5	Bottom Foam 3.95 X 9.08 X 11.98 (Ethafom 220, Black)	1 pcs (1 ea)	90-Start up Operation	3060685
RBEM625V3006101-7	Top Foam 1.20 X 9.08 X 11.98 (Ethafom 220, Black)	1 pcs (1 ea)	90-Start up Operation	3060686

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	90128A287	3	21	0
	97524A032	4	255	0
	APP-1400-E	1	0	0
	RB41011	1	944	0
	RBEM625V3006101-1	1	0	0
	RBEM625V3006101-3	1	0	0
	RBEM625V3006101-5	1	0	0
	RBEM625V3006101-7	1	0	0

Part Specifications

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		Engineering Quality Other ☐ ☐ ☐ ARB (QSI042) Approval																																															
Date : _____		Step #: _____																																																	
Description Work Order Deviation																																																			
Completed By ad hand / Supervisor approval Verification C / QA Coordinator Approval																																																			
sitioned Wrong tside Dimensions ar/Under tolerance t Incorrect t Lost/Missing t Moved wing .sh Misread Turning Sequence																																																			
Root Cause <table border="1" style="width: 100%; border-collapse: collapse;"><tr><td style="width: 50%;">Environment ☐</td><td style="width: 50%;">No Re-verification ☐</td></tr><tr><td>Design ☐</td><td>Operator ☐</td></tr><tr><td>Doc/Data ☐</td><td>Offset/Setup ☐</td></tr><tr><td>Equip/Tooling ☐</td><td>Supplier ☐</td></tr><tr><td>Handling/Pre ☐</td><td>Training ☐</td></tr><tr><td>Material ☐</td><td>Use for Testing ☐</td></tr><tr><td>Internal Transport ☐</td><td>Poor Information ☐</td></tr><tr><td>Tribal Knowledge ☐</td><td>Rushing ☐</td></tr><tr><td>LOA ☐</td><td>Product Improvement ☐</td></tr><tr><td>Substation ☐</td><td>Process Improvement ☐</td></tr><tr><td>Past Expiry Date ☐</td><td>Manufacturing Process ☐</td></tr><tr><td>Misidentified ☐</td><td>Past Due ☐</td></tr></table>		Environment ☐	No Re-verification ☐	Design ☐	Operator ☐	Doc/Data ☐	Offset/Setup ☐	Equip/Tooling ☐	Supplier ☐	Handling/Pre ☐	Training ☐	Material ☐	Use for Testing ☐	Internal Transport ☐	Poor Information ☐	Tribal Knowledge ☐	Rushing ☐	LOA ☐	Product Improvement ☐	Substation ☐	Process Improvement ☐	Past Expiry Date ☐	Manufacturing Process ☐	Misidentified ☐	Past Due ☐	<table border="1" style="width: 100%; border-collapse: collapse;"><tr><td style="width: 50%;">Pressure/Forced ☐</td><td style="width: 50%;">Tempe ☐</td></tr><tr><td>Bending ☐</td><td>Set-up ☐</td></tr><tr><td>Centre Not Concentric ☐</td><td>BOM/F ☐</td></tr><tr><td>Cracks ☐</td><td>Broken ☐</td></tr><tr><td>Crimp/Kink/Ripple/Wave ☐</td><td>Inspect ☐</td></tr><tr><td>Cuffs ☐</td><td>Contarr ☐</td></tr><tr><td>Crushing ☐</td><td>Countei ☐</td></tr><tr><td>Heat Treat ☐</td><td>Cut Too ☐</td></tr><tr><td>Wave/Twist in Tube ☐</td><td>Instructi ☐</td></tr><tr><td>Marks/Chatter ☐</td><td>Drill Holes ☐</td></tr><tr><td colspan="2" style="text-align: center;">OTHER : ☐</td></tr></table>				Pressure/Forced ☐	Tempe ☐	Bending ☐	Set-up ☐	Centre Not Concentric ☐	BOM/F ☐	Cracks ☐	Broken ☐	Crimp/Kink/Ripple/Wave ☐	Inspect ☐	Cuffs ☐	Contarr ☐	Crushing ☐	Countei ☐	Heat Treat ☐	Cut Too ☐	Wave/Twist in Tube ☐	Instructi ☐	Marks/Chatter ☐	Drill Holes ☐	OTHER : ☐	
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Date: 05/10/18
DART Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Fit/Function ☐
Misaligned/off center ☐

Specifications could not be found.

Plex 3/6/18 10:54 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

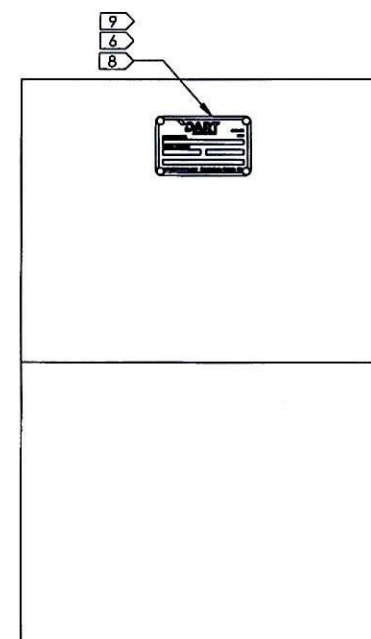
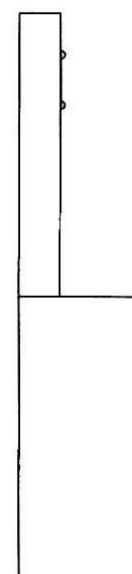
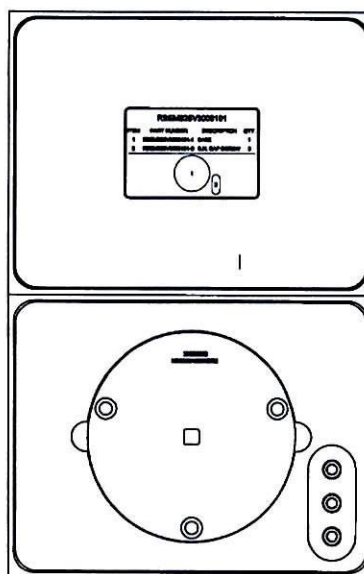
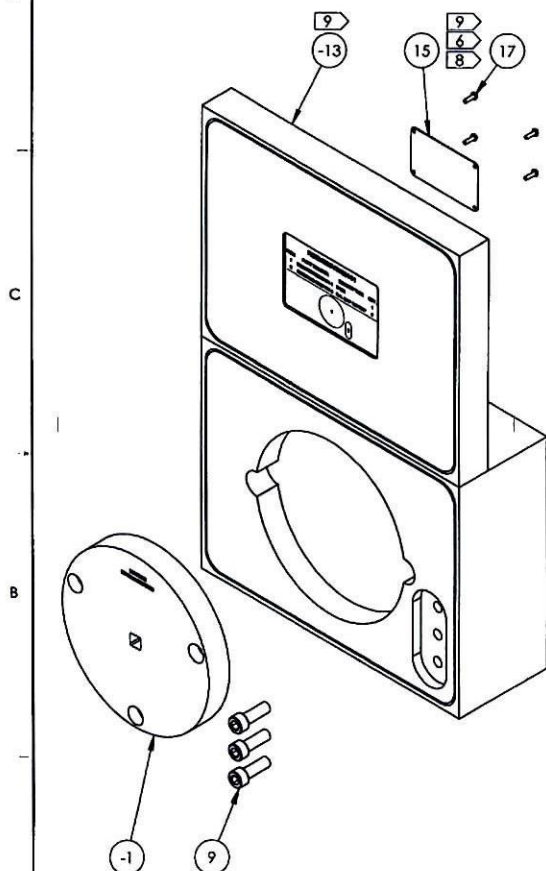
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

ITEM #	QTY	PART #	TITLE	PG
-1	1	RBEM625V3006101-1	BASE	2
-13	1	RBEM625V3006101-13	PACKAGING ASSY	3
9	3	McMaster#90128A287	SOCKET HEAD CAP SCREW M10 x 1.5mm x 30mm	-
15	1	RB41011	DART PLACARD	-
17	4	McMaster#97524A032	RIVET 1/8" x 0.425" LG.	-

REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
1	RELEASED FOR PRODUCTION.	-	7/13/2016	DPD	JAG
2	-1 CH'D DIM WAS 3X Ø.430 THRU ALL Ø.71 .44 EQUALLY SPACED IS 3X Ø.430 THRU ALL Ø.71 .44, WAS Ø.12 000 B.C. IS Ø.6.148 B.C.; ADDED DIM 2X 4.977, (5.843), (144"), (2X (108"), -5 REMOVED DIM 4X R.72, ADDED DIM 4X .45", 4X .75, CH'D B/O INFO WAS (I.R. SPECIALTY) IS (CASE SOLUTIONS); CH'D MATERIAL WAS 720, BLACK IS ETHAFOAM 220, BLACK, -7 REMOVED DIM 4X R.45; ADDED DIM 4X .45", 4X .50; CH'D B/O INFO WAS (I.R. SPECIALTY) IS (CASE SOLUTIONS), CH'D MATERIAL WAS 720, BLACK IS ETHAFOAM 220, BLACK.	-	10/20/2016	SM	JAG
C	TEMPLATE UPDATED, ITEM# -1 COUNTERBORE HOLE SIZE CHANGED, ITEM# -13 PACKAGING ASSY ADDED, ITEM# 17 RIVETS ADDED, R.054 ADDED ON ITEM# -1	17-698	17.11.10	VM	WM



NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) SPEC: N/A
- 5) BREAK ALL SHARP EDGES: N/A
- 6) IDENTIFICATION: ENGRAVE P/N & S/N ON DART PLACARD WHERE IS INDICATED BEFORE INSTALLATION
- 7) REF AIRBUS T/N: M625V3006101
- 8) DART PLACARD CENTERED IN AVAILABLE AREA ON THE TOP LID OF THE PELICAN CASE
- 9) HOT GLUE -5 BOTTOM FOAM & -7 TOP FOAM INTO THE PELICAN CASE AFTER THE INSTALLATION OF THE DART PLACARD ITEM # 15

RBEM625V3006101 MAST NUT EXTRACTOR

DART AEROSPACE Hemelbury, Ontario, Canada	
TITLE: MAST NUT EXTRACTOR	
OWN NO.:	RBEM625V3006101
DESIGN BY:	VM 10/5/2017
DRAWN BY:	VM 11/08/2017
CHECKED:	SAC 11/08/2017
MFG. APPR:	DP 11/08/2017
APPROVED:	VM 11/10/2017
DATE:	11/6/2017
SCALE:	NTS
WEIGHT:	N/A
SHEET 1 OF 6	
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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



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OTHER : _____					